

Date:  
User:

Wednesday, 25/02/2009 2:26:52 PM  
Julie Dawson

# Process Sheet

Dart Aerospace Ltd.

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 46071-2

Estimate Number : 10911

P.O. Number :

This Issue : 25/02/2009 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : LARGE FAB ASSY

Previous Run : 05052

Written By :

Checked & Approved By : JUL 09.02.25

Comment : Est A 05.09.01 New issue KJ/JLM  
Est B 09.01.28 rev.B drawing EC verified by:DD

Drawing Name : LUG ASSEMBLY

Part Number : D3405041

Drawing Number : D3405 REV B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 04/03/2009

Qty: 6 Um: E

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S11GA

304/316 0.125 Sheet



Comment: Qty.: 0.1617 sf(s)/Unit Total: 3.2340 sf(s)  
304/316 .125 Sheet  
(M304S11GA)  
Batch: 109358 1B 9-2-26

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D3405  
Dwg Rev: B  
Prog Rev: B

1B 9-2-26

2-Deburr if necessary

1B 9-2-26

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-2-26

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

502/02/26 x30 counter

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr


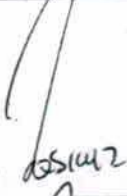
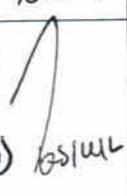
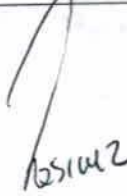
Form using DT8204 as per Dwg D3405

SB 09/03/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3405-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>46071-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/26	# 20	All 30 parts are <sup>0.160"</sup> too short in length. 7.841" Also the hole to hole is cut too short.		SCRAP and Destroy Qty x 30	B 9/2/26	S 09/02/26		S 09/02/26
		R.C. Program not up to date in charge and operator measured off FAT sheet (L&R) not Dwg.		AND Re-line m# 109358  - issue new DFX -  = Re program	B 9/2/26 AP5 09.02.26 09.02.25	S 09/02/26		S 09/02/26
						S 09/02/26		

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 46071

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

A/R

SS Rod

B4537216  
M7676

Most current  
Rev. C Lug.

EL 9-3-11 (K6)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

EL 9-3-11 (K6)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PK 09-03-11

(X6)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-11 (6)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

13:10

OVEN TEMPERATURE:

400°

FINISH TIME:

13:40

UMP/BL

09/03/11

(X6)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 09/03/11

(6)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 46071

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 474

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

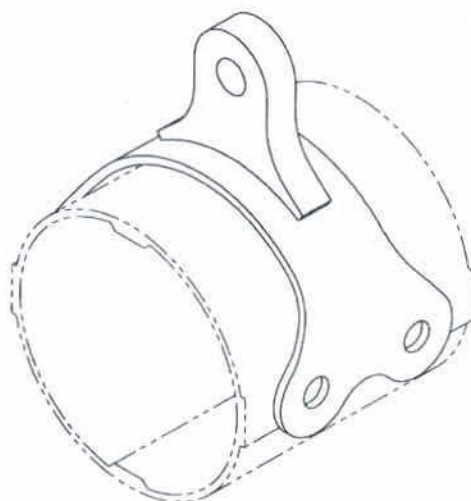
Job Completion



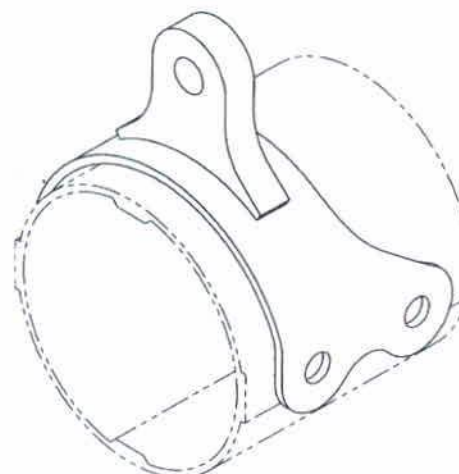
09/03/11

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

B



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

**RELEASED**  
08/12/18

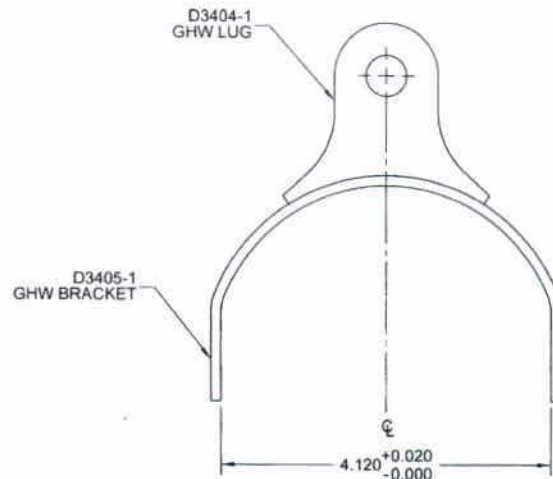
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**NOTES:**

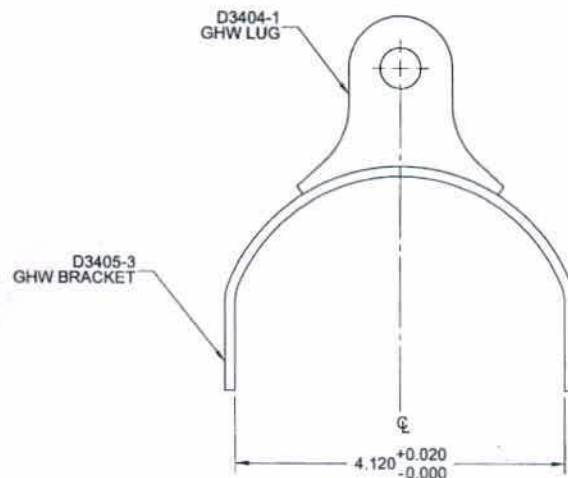
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PART 198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

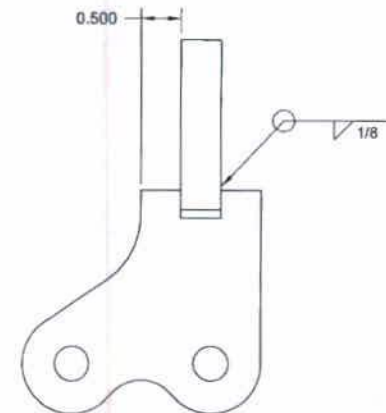
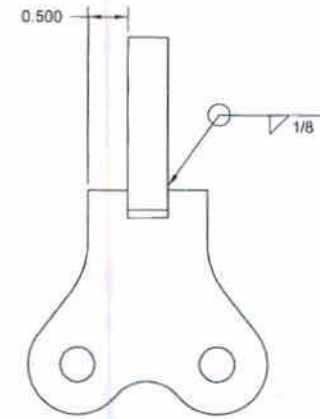




**D3405-041 LUG ASSEMBLY**



**D3405-043 LUG ASSEMBLY**



**RELEASED**  
6/12/14

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D3405</b>	REV. B
MFG. APPR.		TITLE <b>GHW LUG ASSEMBLY</b>	SHEET 2 OF 4
APPROVED			SCALE NTS
DE APPR.			
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